

# Work Order ID 68246

Monday, April 11, 2011 10:18:42 AM



Page 1

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 4/11/2011 Start Qty: 160.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 160.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Cut D2423 extrusion to 0.82"

Batch:

*cut @ meter*

*CL 4/10/11*

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2- deburr

*P/O: 13849*

*CL 4/10/12 (160)*

HAAS CNC vertical machine #1

*issue P/O to meter*

*machine as per dwg D2230 REV. G*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D2230-3

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Item Name: Lug

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Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 160.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC  
Quality Control

QC2 Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd + inspect for transit damage.  
attached cuf c to w10.

11/05/09 160

130



QC  
Quality Control

QC8 Inspect parts - second check

0.00

Memo

0.00

8/10/04

Count  
1160

25019

150



HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

= 7 m. 11/05/05 160x

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Work Order ID 68246**

Monday, April 11, 2011 10:18:42 AM



Page 4

Item ID: D2230-3

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Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 4/11/2011 Start Qty: 160.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 160.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: 476

0.00



Packaging

Memo

0.00

Packaging

11/5/11 160

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 MF

11-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Monday, April 11, 2011 10:18:49 AM

Page 1

Work Order ID: 68246



Parent Item: D2230-3



Parent Item Name: Lug


Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder  
coat ☐ EC IPP REV :E NEW FOLIO # 10-05-  
25 JLM VERIFIED BY:EC  
☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			100	f	377.3100	0.0683	11.50316			



CL 11104112

Location

Loc Qty

Loc Code

MAT006

377.31

43722

161.5

45800

1

63005

214.81

11.50

D2230-3P

X160

16 4/14/11 (160)

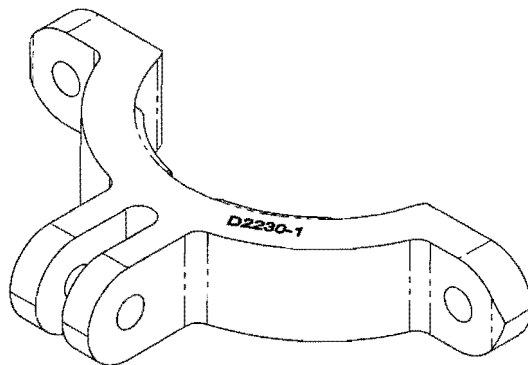
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

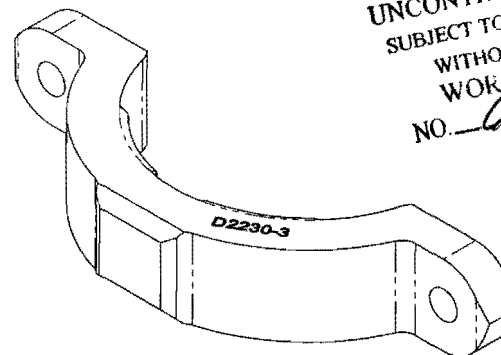
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**NOTE:** Date & initial all entries



**D2230-1 MOUNTING LUG**



**D2230-3 MOUNTING LUG**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68244  
*PL17014*

**RELEASED**  
*09/01/16*



**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN, R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN		BW	
DRAWN		AJS	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.16		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D2230</b>	REV. G
TITLE <b>MOUNTING LUG</b>	SHEET 1 OF 3
SCALE	NTS
COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

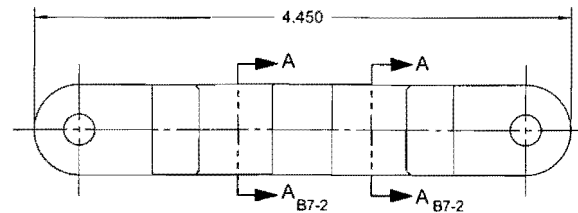
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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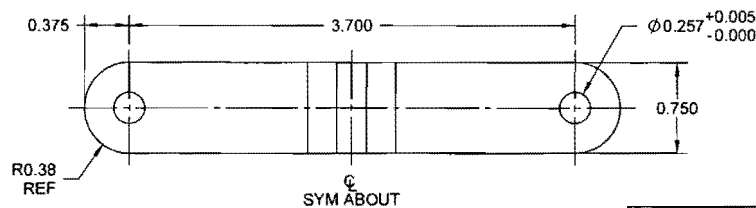
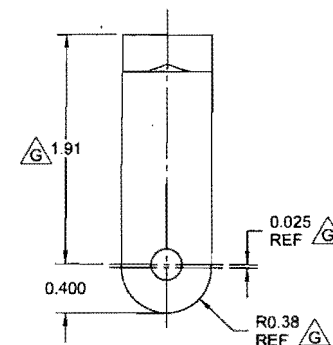
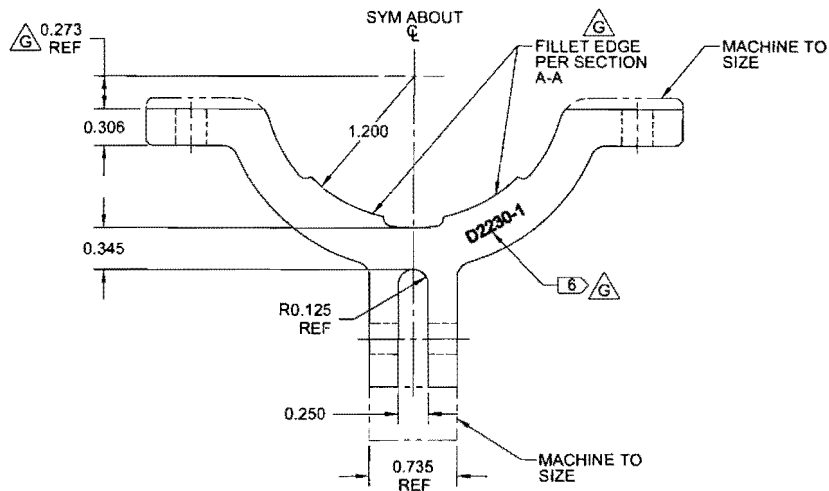
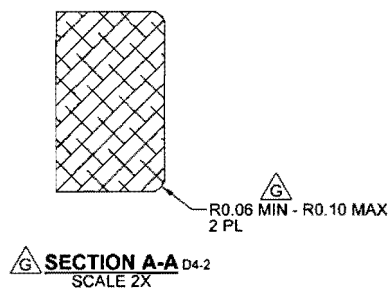
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





u/o 45244



# **D2230-1 MOUNTING LUG**

**RELEASED**  
07/06/25

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

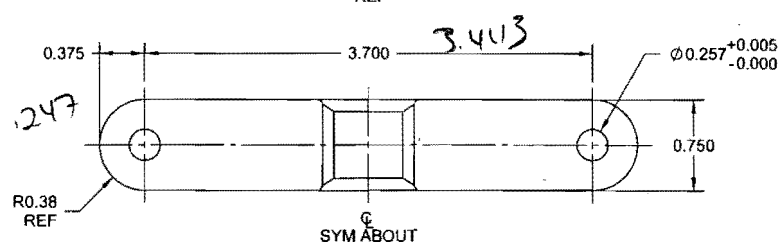
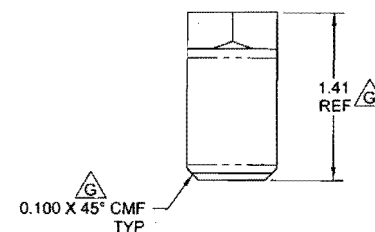
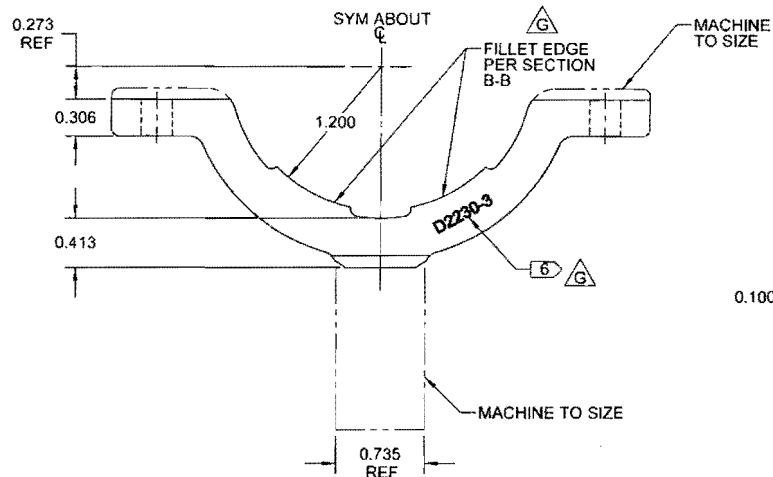
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





**NOTE:** Date & initial all entries

**SECTION B-B** D4-3  
SCALE 2X

R0.06 MIN - R0.10 MAX  
2 PL



**D2230-3 MOUNTING LUG**

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1984 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

RELEASED  
09/04/2014

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO13849**

Purchase Order Date 4/12/2011

PO Print Date 4/12/2011

Page Number 1 of 1

From :  
TEC METAL TECHNOLOGY INC.  
FERRY FOX DRIVE PO BOX 781  
MCKLEEK HILL, QC K0B 1R0

VC-MET003

Buyer	Chantal Lavoie
Requisition Nbr	
Tax Resale Nbr	10127-2607
Terms	Net 30
Currency	CAD
FOB	Destination-Collect

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

4/11/2011

br	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	D3910-1P	CROSSTUBE LUG	4/25/2011 Yes	16.00 Each	Dart Truck	\$31.5500	\$504.80
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B68263				
	D3394-1P	Lug	4/25/2011 Yes	40.00 Each	Dart Truck	\$18.9500	\$758.00
		Special Inst:	MACHINE AS PER DWG D3394 REV. B B68257				
	D2230-3P	LUG	4/25/2011 Yes	160.00 Each	Dart Truck	\$13.6000	\$2,176.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B68246				

PO Total: \$3,438.80

CERTIFICATE OF CONFORMITY  
REQUIRED UPON DELIVERY

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Sbr: 1

Change Date: 4/12/2011





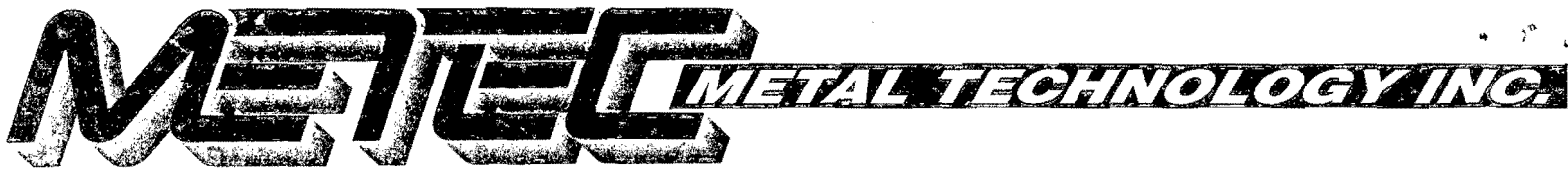
20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 17942  
**Date:** May 04, 2011  
**Page:** 1

<b>Sold to:</b>  <b>Dart Aerospace Ltd.</b> Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 13849	<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-1 Crosstube Lug Material supplied by DART: D2423 B63005	Each	16		
D3394-1 Lug Material supplied by DART: D2423 B63005	Each	40		
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005	Each	160	160	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

160

D2230-3

Mounting Lug

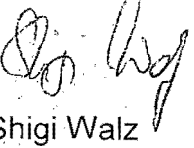
13849

MATERIAL: supplied by DART D2423 B63005

8/11/05/04

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, May 4, 2011

